



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

PC250-530
Job Sheet 200890



Part No: PC250-530

Job Qty: 3 pcs

Part Name: Shaft



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/18/19

Job Tracking No:

Due Date: 10/31/19

Created By: Jennifer Renwick

Type: SOLD

Description: Order 19525

Note: DWG PC250-530 REV:1 IPP REV A 18.02.28 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup	Run		
					Hrs	Hrs	Workcenter / Supplier Lead Time	
110	Mori Seiki TL-40 - 1	3 pcs	10/31/19		1.00	0.25	Mori Seiki TL-40 - 1	JB 19.11.04
120	QC 2	3 pcs	10/31/19		0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	JB 19.11.04
							QC 2 - 63	

DART AEROSPACE LTD.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com



Container No: S229168

Part: PC250-530

Job No: 200890

Serial No/Batch: S229168

Revision: 1

Inspector:

Exo Date:

DAS
62
9-89

DAS
62
9-89

Plex 9/18/19 1:21 PM Dart.Renwick.Jennifer

9/18/2019

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
130 QC 8	3 pcs	10/31/19	0.00 0.00		QC 8 - 12	
					QC 8 - 14	Am 19/11/04
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
140 Outsource - 1 - Heat Treat	3 pcs	10/31/19			MEI001-VC HZ002	2019-11-08
150 Packaging 2-1 - Receive - B4B	3 pcs	10/31/19	0.00 0.00		Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	DP NOV 18 2019
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	

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				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
160 QC 6	3 pcs	10/31/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	NOV 19 2019 40
				QC 6 - 81	9-89
170 Packaging 3-1 - Stock - B4B	3 pcs	10/31/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	28
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	

9/18/2019

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	3 pcs	10/31/19	0.00 0.00	QC 21 - SA - 21	DAG
				QC 21 - SA - 70	21
				QC 21 - SA - 53	NOV 19 2019

Part Op 110 - (MORI SL-154 LATHE) 1-Machine as per DWG. FOLIO REV: AA DWG REV: 1 2-Debur
 Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - 1-Issue P/O; 450.59 Heat treat RC 44-46 2-Bead blast 3-Apply LPS-3 rust inhibitor 4-Material type; 4140
 5-Certificate of Conformity is required
 150 - (Pac2-Receive & Inspect for Damage & Mat'l Certs.)
 160 - (QC6- All purchased or subcontracted products)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R1.000	AISI 4140 Quenched & Tempered Steel Round Bar 1.000"	1.0350 ft (.345 ea)	110-Mori Seiki TL-40	
	Dia.		- 1	<u>5124464</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Mori Seiki TL-40 - 1	MT-4140QT-R1.000	1	7	0
	<u>RO.875</u> <u>H.F</u>			

Part Specifications
Specifications could not be found.

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Tel (613) 632-5200

PURCHASE ORDER POHB045059



Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S 1R4 Canada
Phone: 866 257 6395

Attention: Ananth, Nimmy

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045059

PO Date: 11/8/19

Due Date: 11/19/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	200692	PC250-300	PC250-300 Rev 1	Load Beam 1-Issue P/O Heat treat RC 53-56 2-Bead blast 3-Material type 4140 4-Apply LPS-3 to ALL steel parts 5-Certificate of Conformity is required	Firmed	-	11/19/19	3 pcs	0 pcs	3 pcs	\$64.5133/pcs	\$193.54
2	202969	RBE117-12020-W14	RBE117-12020-W14 Rev B	Mounting Ring Input Main Gear Box (Outsource process - Heat Treat) 1-Issue P/O RC 40-45 2-Bead blast 3. Material 4140 4-Apply LPS-3 to ALL steel parts 4-Certificate of Conformity is required	Firmed	-	11/19/19	8 pcs	0 pcs	8 pcs	\$16.415/pcs	\$131.32
Line Item Note: **4 blanks sent; will be cut into 2 = 8 pcs												
3	200691	PC250-700	PC250-700 Rev 2	Lever Arm 1-Issue P/O RC 42-44 2-Bead blast 3-Material type 4140 4-Apply LPS-3 to ALL steel parts 5-Certificate of Conformity is required	Firmed	-	11/19/19	4 pcs	0 pcs	4 pcs	\$43.75/pcs	\$175.00

Plex 11/15/19 10:14 AM Dart.Guerin.Kimberley



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PURCHASE ORDER POHB045059



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	201020	RBE117-15004W6-17	RBE117-15004W6 Rev B	Ring 1-Issue P/O RC 48-52 2-Bead blast 3-Material type O1 4-Apply LPS-3 to ALL steel parts 5-Certificate of Conformity is required	Firmed	-	11/19/19	7 pcs	0 pcs	7 pcs	\$11.4285/pcs	\$80.00
5	200895	RBE105-14181W4-15	RBE105-14181W4 Rev C	Base 1-Issue P/O RC 48-52 2-Bead blast 3-Material type O1 4-Apply LPS-3 to ALL steel parts 5-Certificate of Conformity is required	Firmed	-	11/19/19	6 pcs	0 pcs	6 pcs	\$13.3333/pcs	\$80.00
6	201019	RBE117-15004W6-15	RBE117-15004W6 Rev B	Spacer Ring 1-Issue P/O RC 48-52 2-Bead blast 3-Material type O1 4-Apply LPS-3 to ALL steel parts 5-Certificate of Conformity is required	Firmed	-	11/19/19	7 pcs	0 pcs	7 pcs	\$11.4285/pcs	\$80.00
7	200890	PC250-530	PC250-530A Rev 1	Shaft 1-Issue P/O Heat treat RC 44-46 2-Bead blast 3-Apply LPS-3 rust inhibitor 4-Material type 4140 5-Certificate of Conformity is required	Firmed	-	11/19/19	3 pcs	0 pcs	3 pcs	\$26.6666/pcs	\$80.00
8	201077	PC250-610	PC250-610 A	Pin 1-Issue; P/O RC 42-44 2-Bead blast 3-Material type 4140 - lightly oil parts after bead blast 4- Certificate of Conformity is required	Firmed	-	11/19/19	20 pcs	0 pcs	20 pcs	\$4.00/pcs	\$80.00
Grand Total:												\$899.86

Guerin



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PURCHASE ORDER
POHB045059



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/15/19 10:14 AM Dart.Guerin.Kimberley

Shipping Ticket

Sold To: 1448
DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Ship To: 168772
DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Page 1 of 1

Purchase Order Number	Packing List No	Customer Job No	Route	Carrier
POHB045059				

Quantity	Part No. / Part Name / Part Description	Pounds
	3 PCS MATERIAL 4140 BEAD BLAST AND HEAT TREAT TO 44-46RC C OF C, PRT# PC250-530, JOB# 200890, RUSH	

Container Type	# Of Containers	Cust Cont Id	Container Type	# Of Containers	Cust Cont Id
BOX	1				

NOTICE: OUR LIABILITY IS LIMITED TO OUR INVOICE CHARGES ONLY

Shipped Complete

Quantity Shipped: 3

Pounds Shipped: 2.00

RECEIVED
NOV 18 2019
DART AEROSPACE LTD.

Order No.: 171981

Shipped Complete

Quantity Shipped: 3.00

Received By:

Date:

Pounds Shipped: 2.00

Sold To: DART AEROSPACE LTD.

Shipped ON: 11/14/2019

Certification

Date: 11/15/2019

Entry Date: 11/14/2019

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: POHB045059

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 4140

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
3	3 PCS MATERIAL 4140 BEAD BLAST AND HEAT TREAT TO 44-46RC C OF C, PRT# PC250-530, JOB# 200890, RUSH	2

Insp. Type	Scale	Minimum	Maximum	Number	Other
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Customer Requirements:

Harden rockwell

Results:

Harden ROCKWE 44. 46. 45. TESTED AS PER SAMPLING PLAN
HEAT TREATED TO 45 RC AS PER CUSTOMER REQUEST

DAS
40
350

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY). ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER, IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OF CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE AFORESAID LIMITATION OF LIABILITY IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.

RICK BUGGY

QUALITY CONTROL

ATLANTIC HEAT TREATING 2001 LTD